

Date: Thursday, 15/01/2009 11:13:13 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DECK PLATE,FWD ,350 LITTER KIT	
Job Number :	44775			
Estimate Number :	11104			
P.O. Number :		Part Number :	D2364	
This Issue :	15/01/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D2364 REV.F	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	41423	Drawing Revision :	F	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	30/01/2009	Qty: 6 Um: Each
Written By :				
Checked & Approved By :	<u>JLD 09.01.16</u>			
Comment :	EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s)
 2024-T3 .063 Aluminum sheet
 (M2024T3S063)
 Batch: 110337 AB 9-1-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2364
 Dwg Rev: F
 Prog Rev: F

AB 9-1-26

(7)

2-Deburr if necessary AB 9-1-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 09/01/27 (x7)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D2364

09/01/28 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:13:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 44775

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary *195*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/28 *(X7)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 09-01-28 *(X9)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 105042

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

15:15
320°
15:45

BR 09-01-29 *(7)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-29 *(X7)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *185*

9/2/2

SD

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

Job Completion



MF 09-02-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>H4775</u>
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.628	x			
Ø0.171	+0.005/-0.000	.173	x			
0.354	+/-0.010	.352	x			
11.242	+/-0.010	11.242	✓			
3.031	+/-0.010	3.035	x			
1.903	+/-0.010	1.904	x			
1.128	+/-0.010	1.128	x			
0.354	+/-0.010	.354	✓			
1.340	+/-0.005	1.336	✓			
2.326	+/-0.010	2.328	x			
3.312	+/-0.010	3.314	x			
4.298	+/-0.010	4.299	x			
5.284	+/-0.010	5.283	✓			
6.151	+/-0.010	6.151	✓			
6.270	+/-0.010	6.271	✓			
0.354	+/-0.010	.352	x			
3.031	+/-0.010	3.036	✓			
Ø0.656	+0.005/-0.000	.656	x			
5.003	+/-0.010	5.003	✓			
4.605	+/-0.010	4.603	x			
1.776	+/-0.010	1.774	✓			
0.980	+/-0.010	.983	x			
4.487	+/-0.010	4.487	x			
7.192	+/-0.010	7.192	x			
7.567	+/-0.010	7.570	x			
7.942	+/-0.010	7.944	✓			
Ø0.191	+0.005/-0.000	.192	x			
Ø0.197	+0.005/-0.000	.198	x			
11.145	+/-0.010	11.147	✓			
12.181	+/-0.010	12.181	x			
11.378	+/-0.010	11.378	✓			
11.776	+/-0.010	11.776	x			
12.173	+/-0.010	12.173	x			
4.690	+/-0.010	4.690	✓			
Ø 0.250	+0.005/-0.000	.252	✓			
Ø 3.141	+/-0.010	3.142	✓			
Ø 0.171	+0.005/-0.000	.173	x			

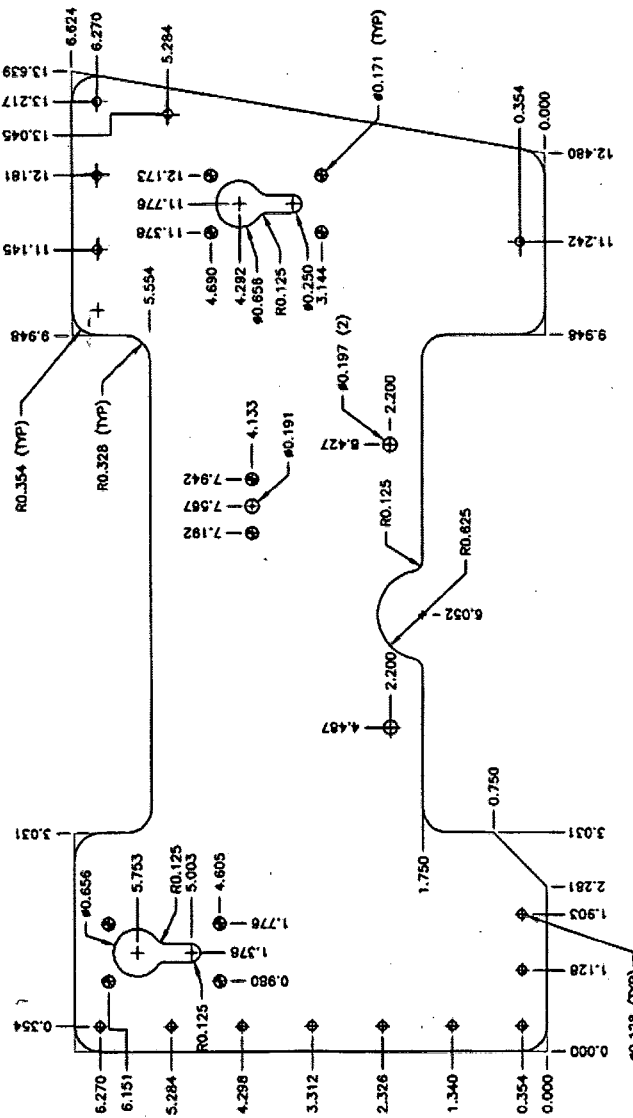
Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-1-27</u>	Date: <u>09/01/27</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	



RELEASED
98/06/22 KE

COUNTER SINK HOLES:
 ◆ C'SINK Ø0.225 x 100° (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)
 ◎ C'SINK Ø0.308 x 100°



DESIGN <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DA</i>		APPROVED <i>CA</i>		DRAWING NO. D2364 REV. F SHEET 1 OF 1	
DATE 98.06.19		TITLE LITTER DECK PLATE, 350		SCALE 2:5	
A	95.01.14	NEW ISSUE			
B	95.02.09	MOVED KEYWAY			
D	95.03.06	0.191 WAS 0.197			
E	95.10.06	GEOMETRY CHANGES			
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)			

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

MATERIAL FINISH: TOLERANCE: SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
~~WORK ORDER~~